

Date: Wednesday, 4/25/2007 2:39:57 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT ASSEMBLY
Job Number	: 32065		
Estimate Number	: 10732		
P.O. Number	: <i>NIA</i>	Part Number	: D23241
This Issue	: 4/25/2007	S.O. No.	: <i>NIA</i>
Prsht Rev.	: NC	Drawing Number	: D2324 REV. C
First Issue	: <i>NIA</i>	Project Number	: N/A
Previous Run	: 31270	Drawing Revision	: C
	Type : SMALL /MED FAB	Material	: <i>NIA</i>
Written By	: <i>[Signature]</i>	Due Date	: 5/10/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	1 Um: Each
Comment	: Est: E 03.02.28 Reformat; Incorporated D2324-3 & D2324-5 KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	32065A	STOP
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Comment: Sub-Component STOP

D2324-3 B *B25820 A*

X1

2.0	32065B	STRAP
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Comment: Sub-Component STRAP

D2324-5 B *28062*

X2

3.0	AN312A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt

M 18310

X2

4.0	AN960JD10	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Washer

M 100743

X4

5.0	MS21042L3	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Nut

M 104215

X2

m107/05/07

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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X1

Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D2324.

m107/05/07

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: FD Date: 02/05/00
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB

07/05/07

①

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

MA

07-05-08

①

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/05/08

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/05/08

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/08 ①

Job Completion



07/05/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

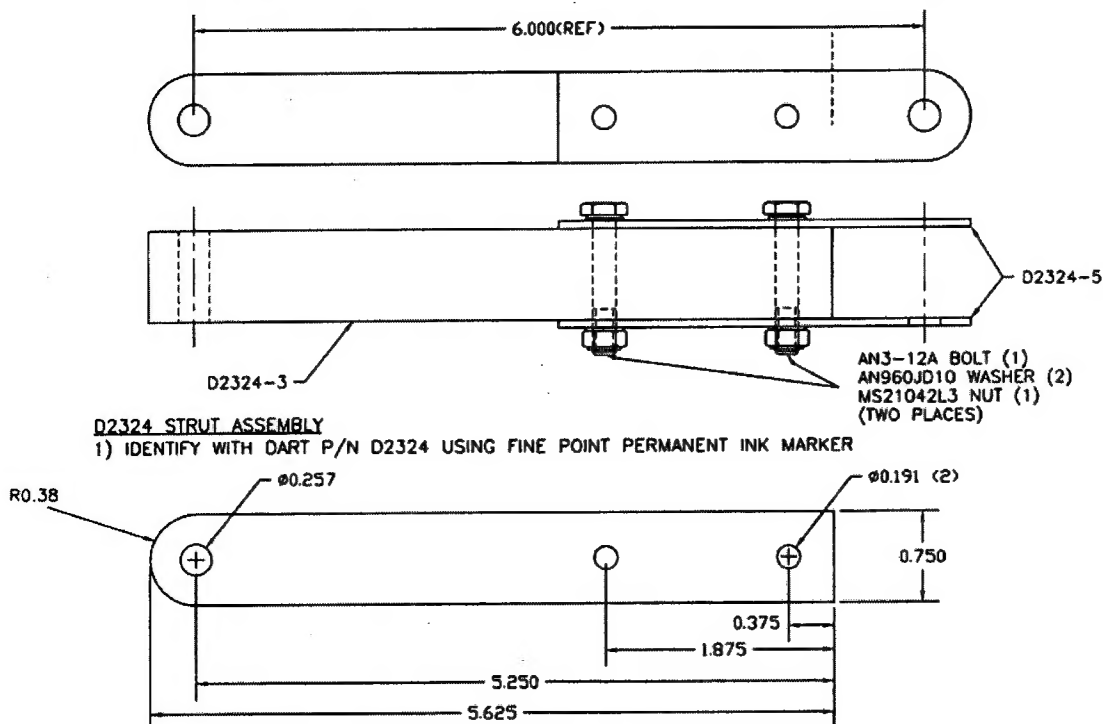
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

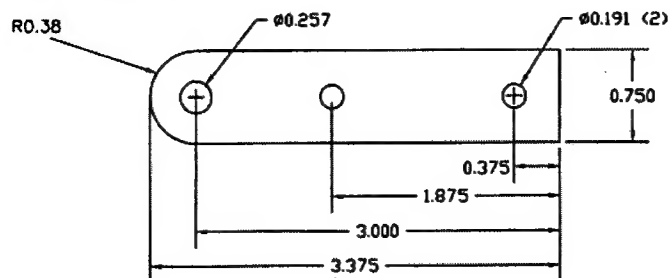
DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	PH	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
<i>[Signature]</i>	<i>[Signature]</i>	D2324	SHEET 1 OF 1
DATE	TITLE	SCALE	
04.12.14	STRUT		
A	94.11.08	NEW ISSUE	
B	96.05.07	UPDATE MATERIALS	
C	04.12.14	UPDATE NOTES	

RELEASED04.12.16 *[Signature]***D2324 STRUT ASSEMBLY**

1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER

D2324-3

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
(REF DART SPEC. M6061T6B0.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2324-5**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32065